

Work Order ID 60375

July 6, 2010 2:58:13 PM



Page 1

Item ID: D3766-2

Accept



Setup

Start



Revision ID:

Item Name: Front Rail, RH

Stop



Start Date: 7/06/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/20/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CS

Date: 10/7/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3766

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg, D3766 2-drill holes thru to finish size as per dwg D3766 using DT9413, drill holes labelled #2 3- deburr

=> m-d

10/07/07

4x

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/07/08

4x

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> M 10/07/08

4

φ

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60375

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Page 2

Item ID: D3766-2

Accept



Setup

Start



Revision ID:

Item Name: Front Rail, RH

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Start Date: 7/06/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run

Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

4. BR 10-7-8.

140



Identify as per dwg & Stock Location: 204

0.00

Packaging

Memo

0.00

Packaging

Carp/s (4)

150



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Part 09
WF
10-7-8

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60375

Parent Item: D3766-2

Parent Item Name: Front Rail, RH


Start Date: 7/06/10

Required Date: 7/20/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-27 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	75.3240	2.7927	11.75874			
													
6061T6 RD TUBE 1.00 X .188W													

Location

Loc Qty

Loc Code

MAT 114520 ✓ 12.975
MAT016 113511 12.975
114089 62.349
113511 15.516
114089 46.833

11.75874 10/07/07
m-k

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

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WORK ORDER

NO. 60375

CZ1d716

NOTES:

1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER VWV-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

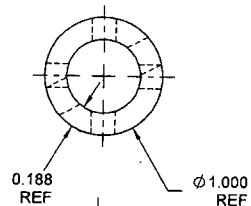
7) WEIGHT: D3766-1, 1.55 lbs

D3766-2, 1.55 lbs

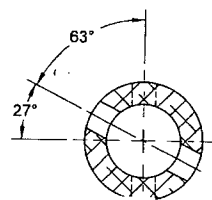
D3766-3, 1.55 lbs

RELEASED
08.07.10 *MP*

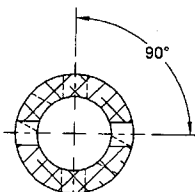
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MP</i>	D3766	SHEET 1 OF 4
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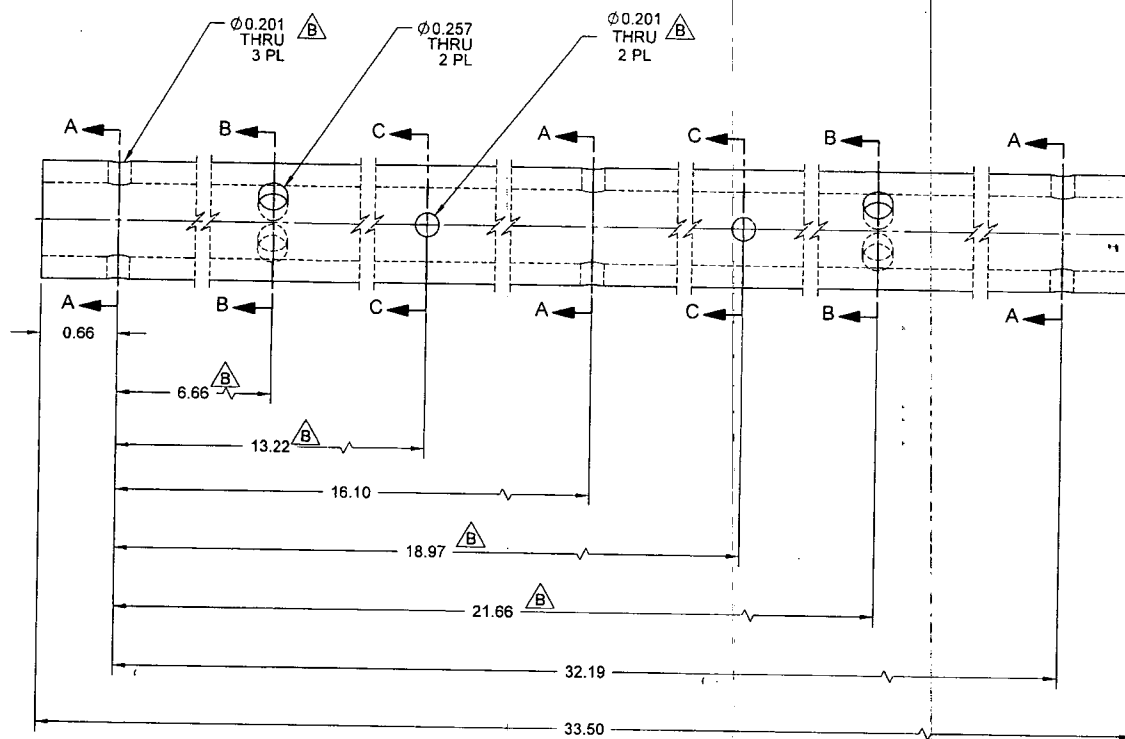
SECTION A-A



SECTION B-B



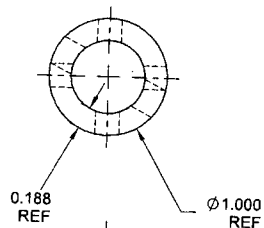
SECTION C-C



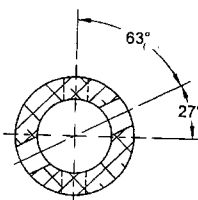
D3766-1 FRONT RAIL, LH

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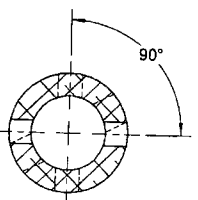
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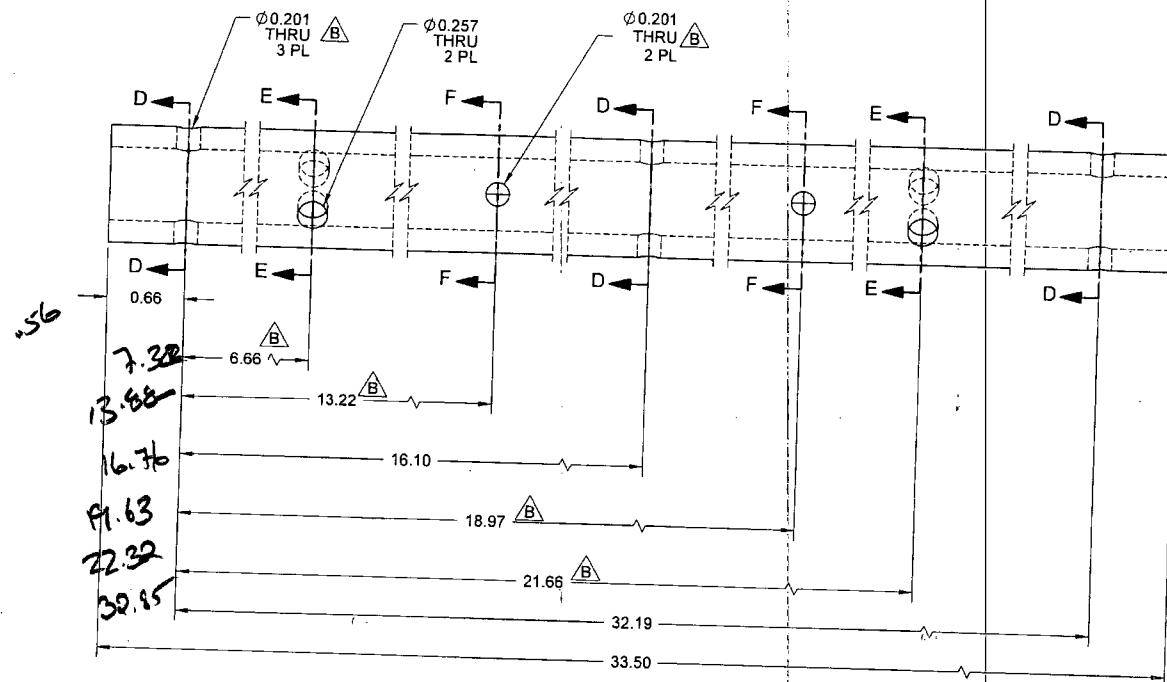
SECTION D-D



SECTION E-E



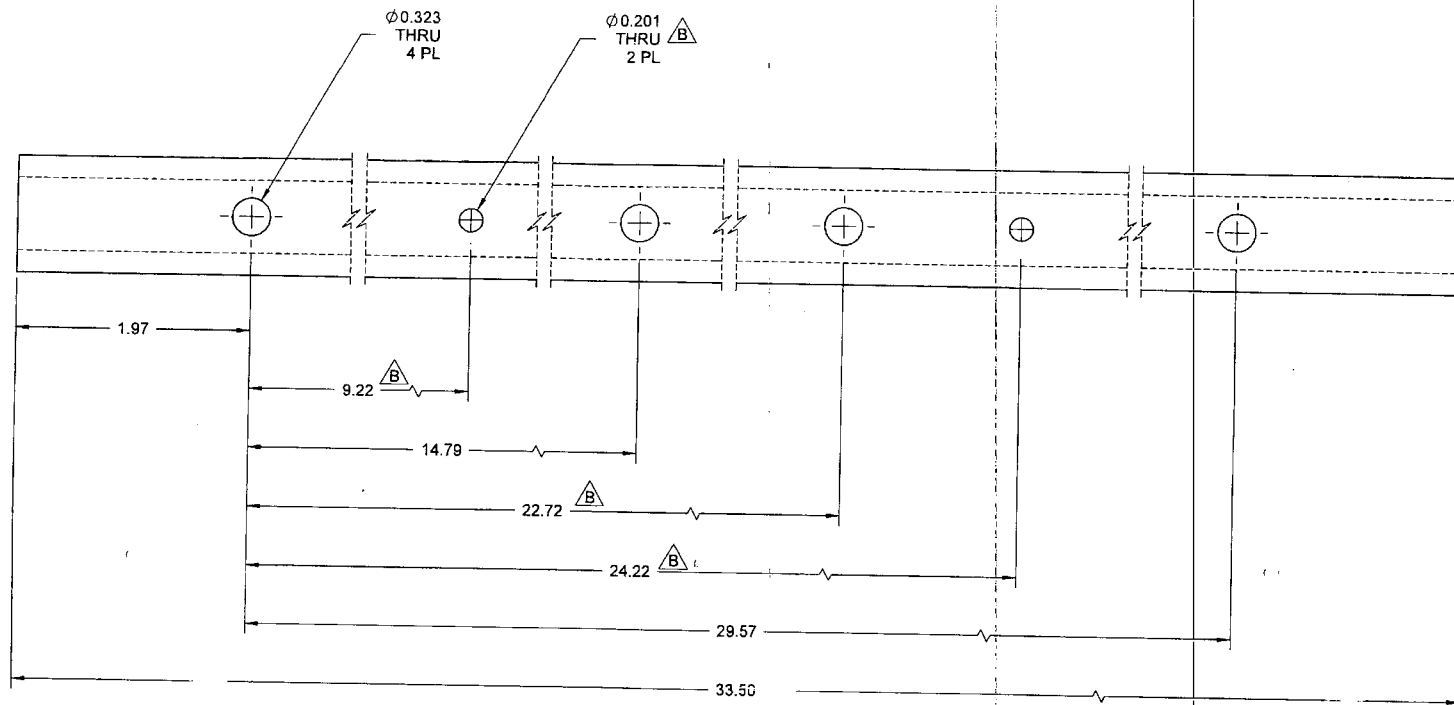
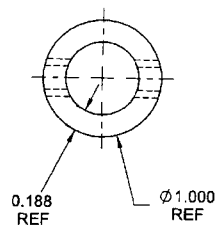
SECTION F-F



D3766-2 FRONT RAIL, RH

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D3766-3 REAR RAIL

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DRAWN	HS	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3766 REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE RAIL SCALE NTS
DE APPR.	<i>[Signature]</i>	
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